

Date: Wednesday, 09/07/2008 1:29:41 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 40402
Estimate Number : 10858
P.O. Number :
This Issue : 09/07/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 09/07/2008 Type : SMALL /MED FAB
Previous Run : 34708
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 05-11-22 JLM
Est Rev:B Now on Waterjet 08-05-14 JLM Verified By:DD

Drawing Name : RING
Part Number : D34075
Drawing Number : D3407 REV D
Project Number : N/A
Drawing Revision : D
Material :
Due Date : 16/07/2008 Qty: 40 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M174B0250X4000 17-4 SS Bar 1/4" X 4"



Comment: Qty.: 0.2799 Ft(s)/Unit Total: 11.1972 Ft(s)
Material: 17-4ph SS 4.00" X .250" THK
Identify for D3407-5
Batch: 107951

ml 08 07 10

37

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3407
Dwg Rev: D
Prog Rev: D

ml 08 07 10

2-Break edges on grinder as per Dwg D3407

08/07/15 37 Am 37

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 08 07 10

37

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

508/07/15 37 Am 37

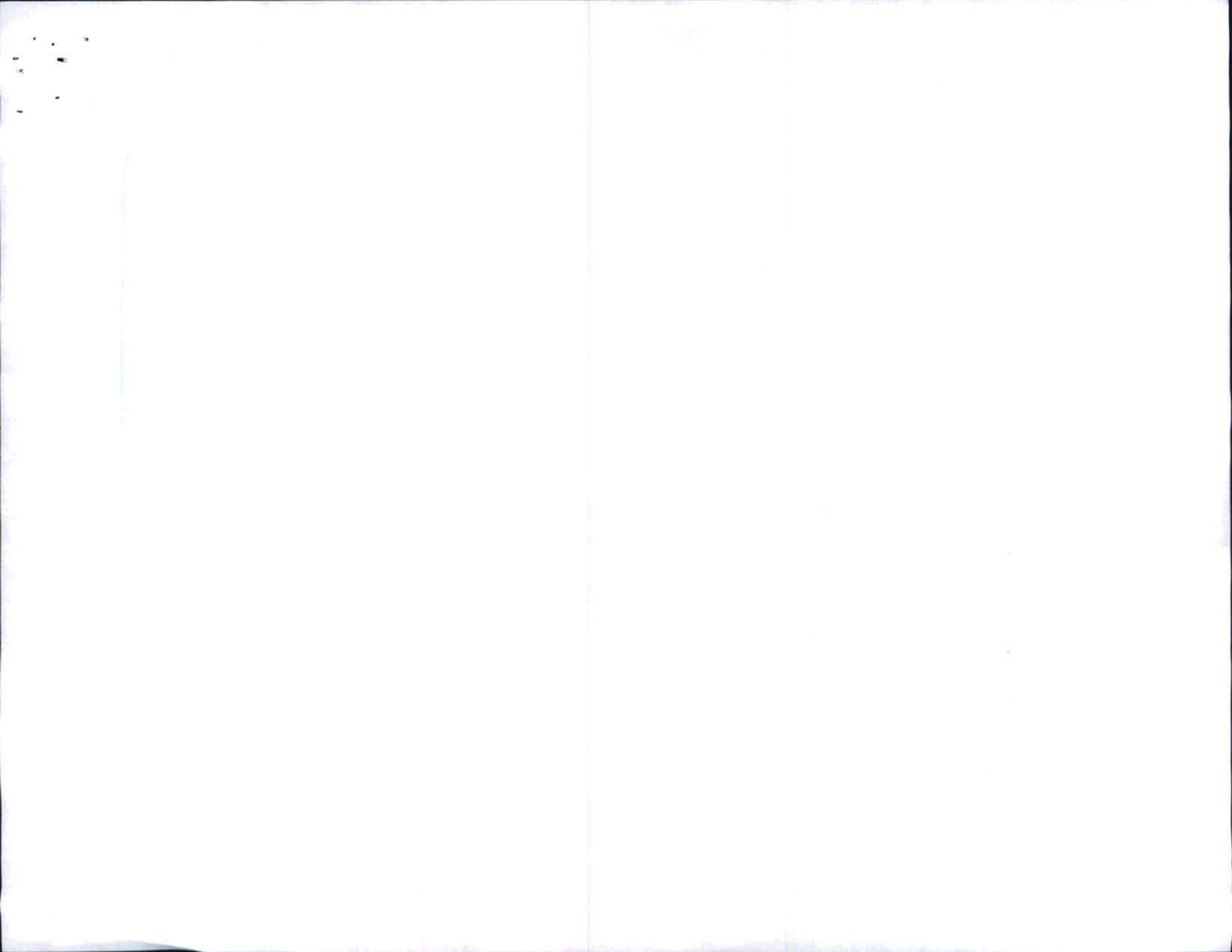
5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: Cef

8/7/16

37x
50



Date: Wednesday, 09/07/2008 1:29:41 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 40402

Part Number: D34075

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/17

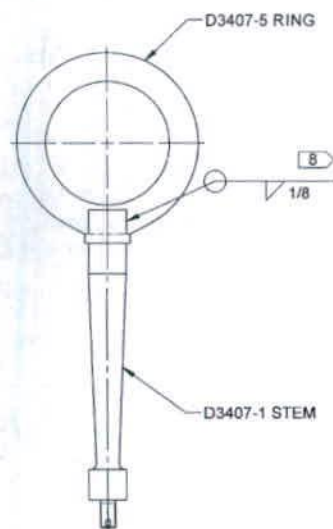
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Job Completion

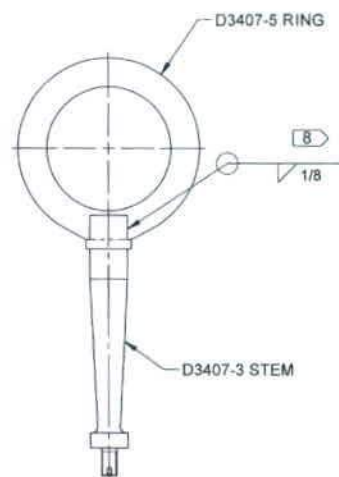


MF 08-07-16

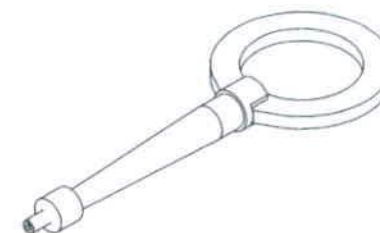
QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3407-041	TOW RING
	X	D3407-043	TOW RING
1		D3407-1	STEM
	1	D3407-3	STEM
1	1	D3407-5	RING



D3407-041 TOW RING



D3407-043 TOW RING



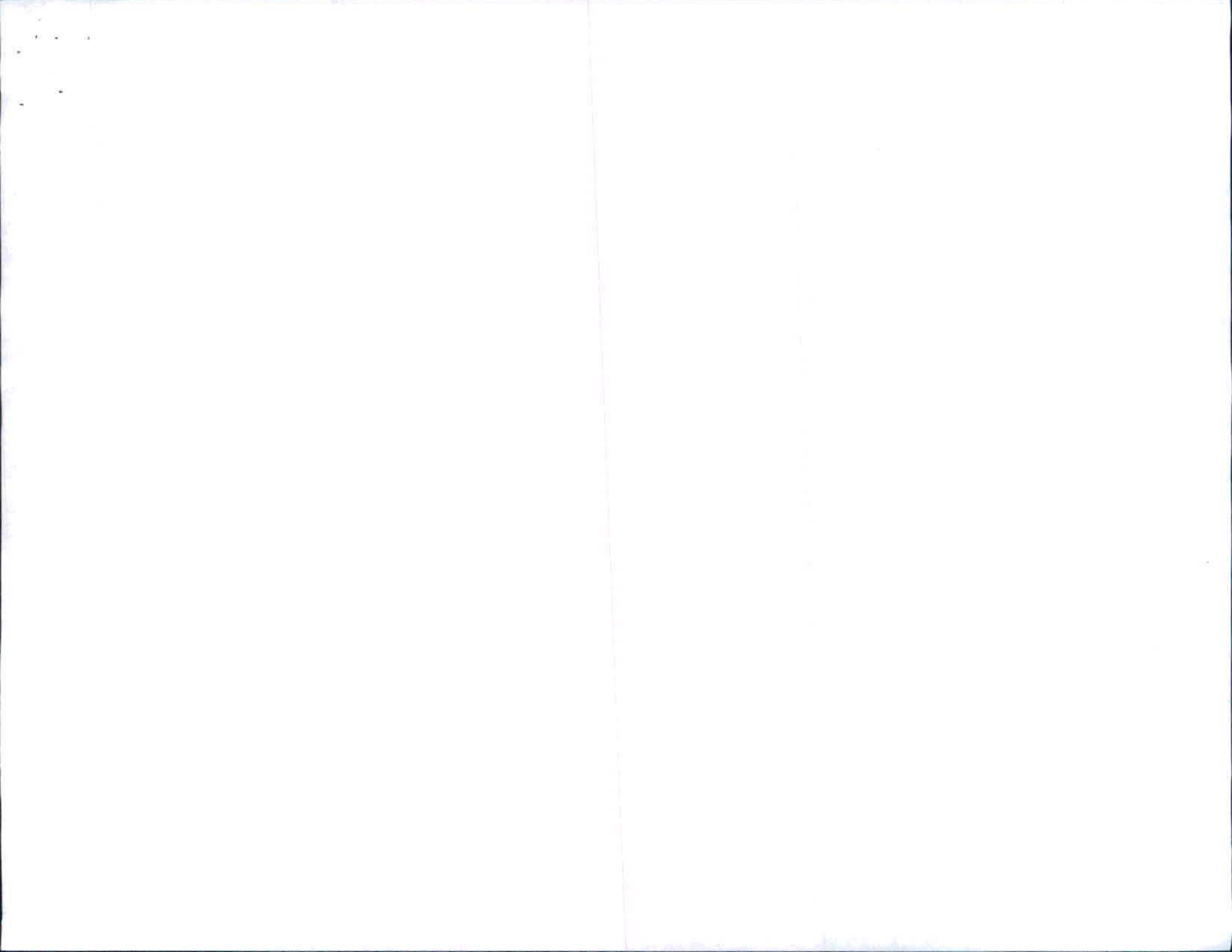
RELEASED
05-13-14

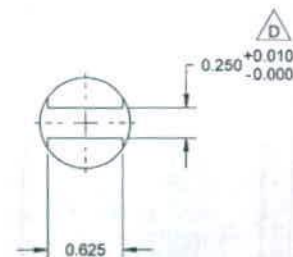
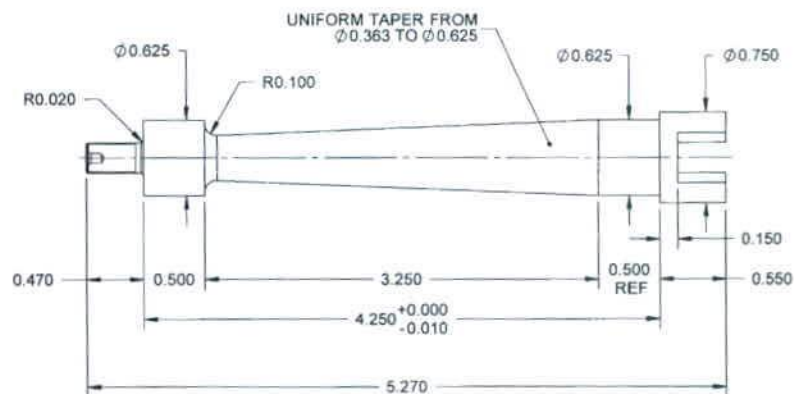
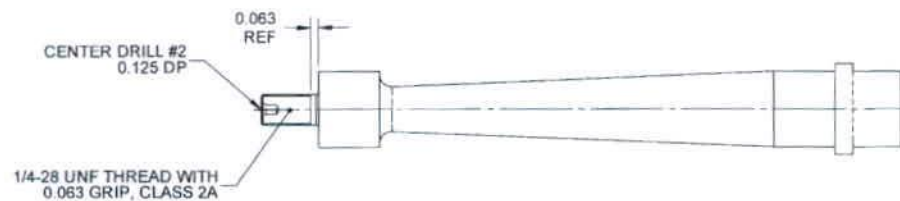
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

REV.	DESCRIPTION	BY	DATE
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT WWASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
DESIGN	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN	DRAWING NO. D3407		
CHECKED	REV. D		
MFG. APPR.	SHEET 1 OF 4		
APPROVED	TITLE TOW RING		
DE APPR.	SCALE NTS		
DATE	08.04.07		

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D3407-1 STEM

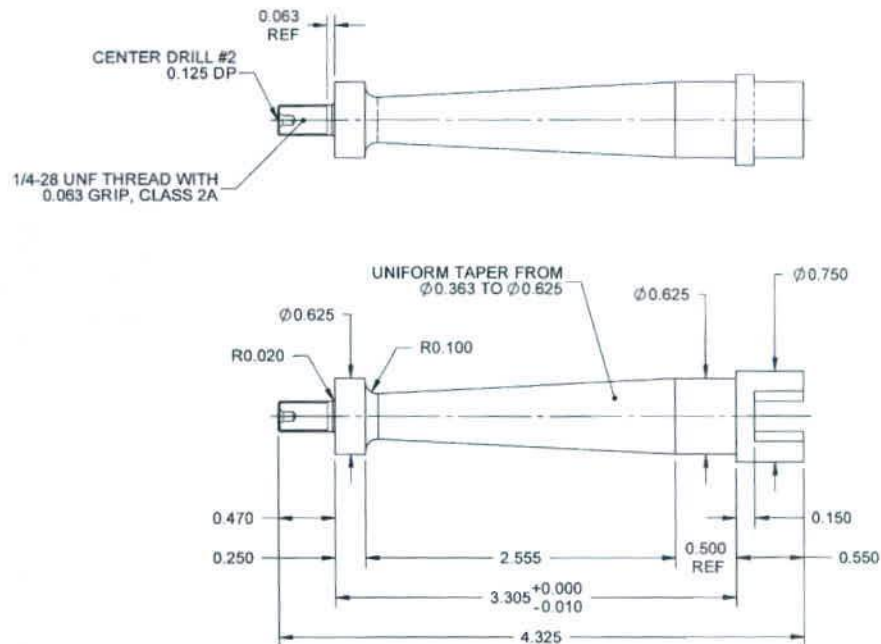
NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

Wb40402

RELEASED
08-06-13

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3407	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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D3407-3 STEM

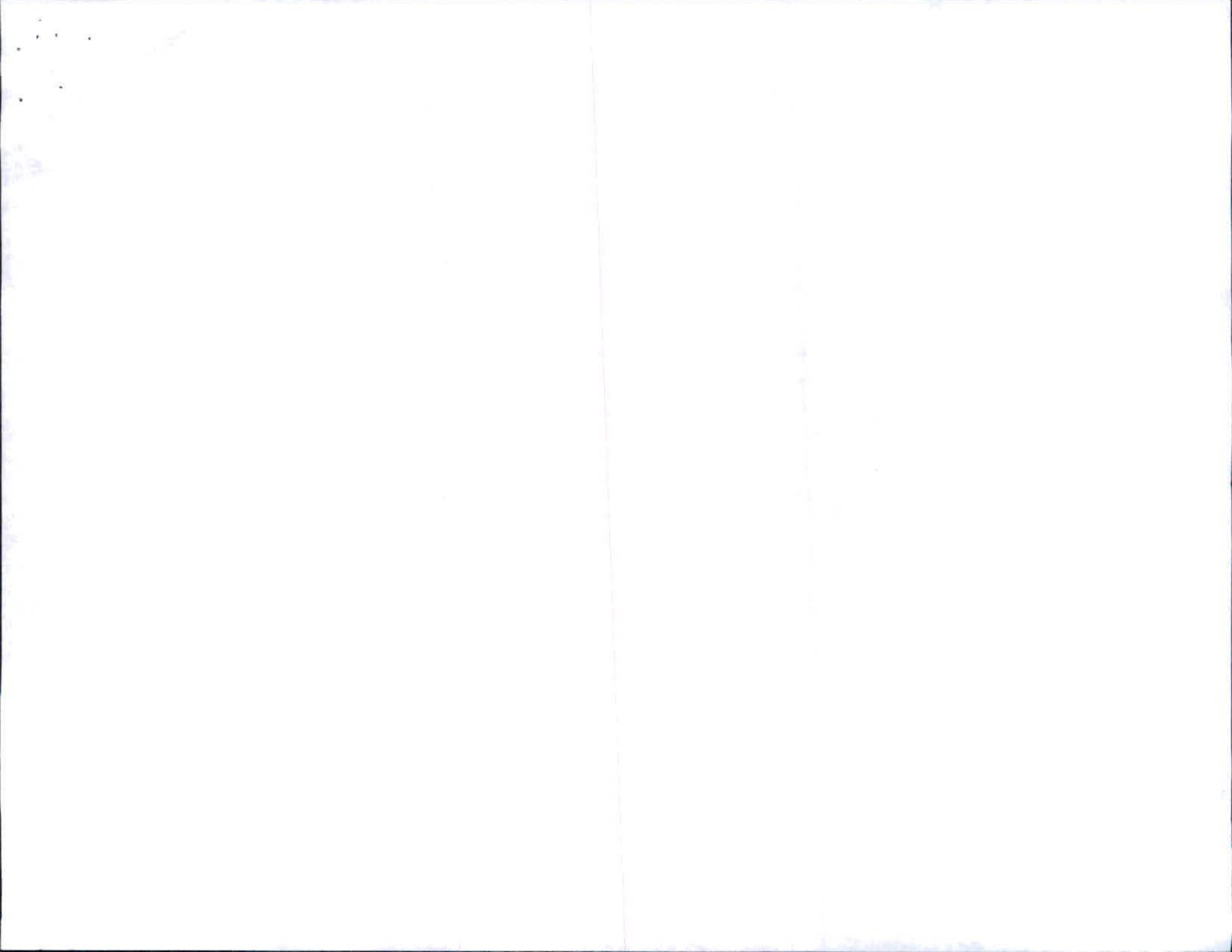
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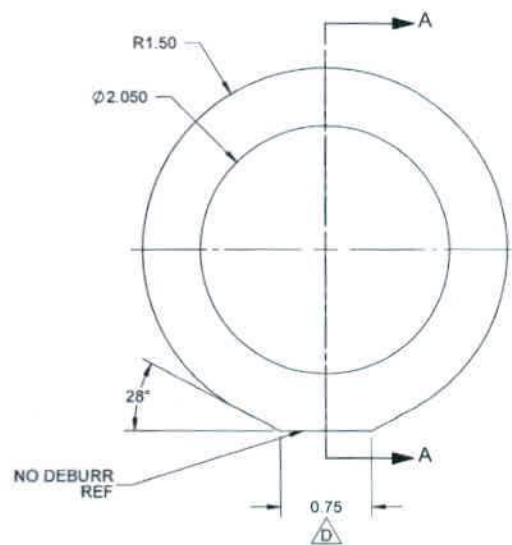
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.27 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3407	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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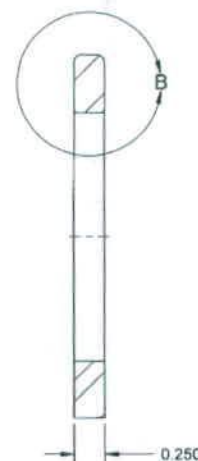
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08-03-13 141

Wb 40402

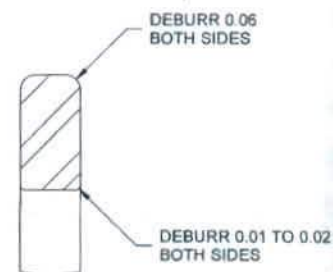
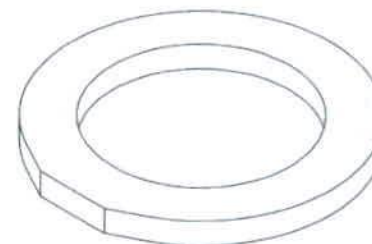




D3407-5 RING



SECTION A-A



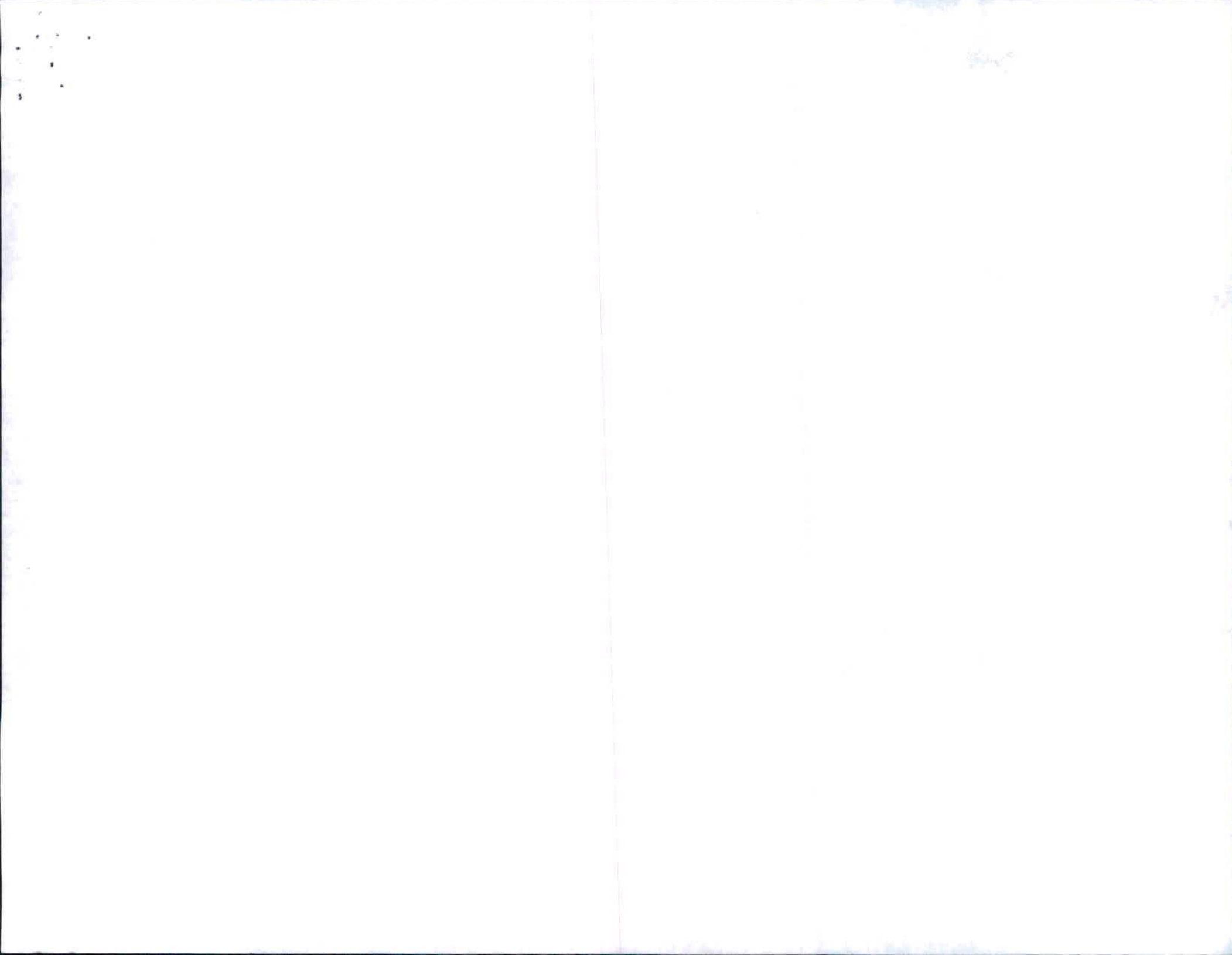
**DETAIL B
SCALE 2X**

RELEASED
08-05-13-1110

- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

W/6 40402

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3407	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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